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IS 2636 (1972): Wing Nuts [PGD 31: Bolts, Nuts and Fasteners Accessories]

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IS : 2636 - 1972

Indian Standard

(Reaffirmed 2001)

SPECIFICATION FOR WING NUTS

(First Revision)

1. Scope — Requirements for wing nuts of two types in the size range 2 to 24 mm.

2. Types — Two types of wing nuts are covered as given below:

Type A — Wing nut made by stamping or casting in the shape as given in Table 1 in the size range 2 to 24 mm.

Type B — Wing nut made by cold forging in the shape as given in Table 2 in the size range 3 to 20 mm.

TABLE 1 DIMENSIONS FOR WING NUTS, TYPE A (HOT STAMPED OR CAST)

(*Clauses* 2 *and* 3.1)

All dimensions in millimetres.

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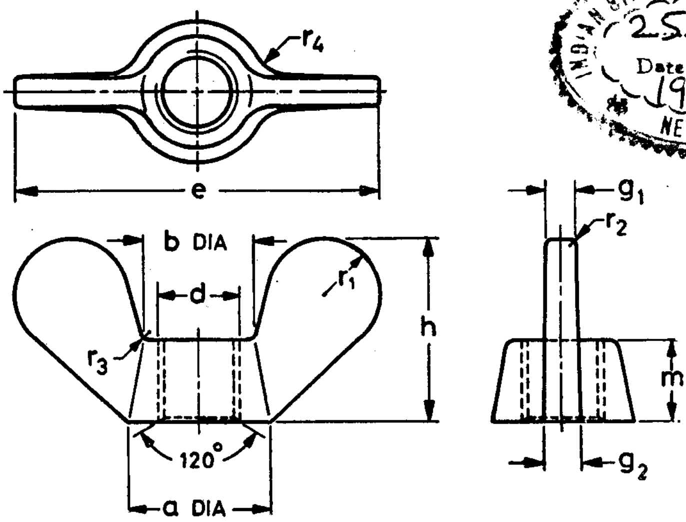

Size *d*		M2	M2·5	M3	M4	M5	M6	M8	M10	M12	M16	M20	M24
a(js16)	*Nom* *Max* *Min*	8 8·45 7·55				10 10·45 9·55	12 12·55 11·45	16 16·55 15·45	20 20·65 19·35	23 23·65 22·35	28 28·65 27·35	36 36·80 35·20	45 45·80 44·20
b	*Nom*	6				8	10	12	16	19	22	28	36
e(js16)	*Nom* *Max* *Min*	20 20·6 19·4				25 25·6 24·4	32 32·8 31·2	40 40·8 39·2	50 50·8 49·2	64 65·0 63·0	72 73·0 71·0	90 91·1 88·9	112 113·0 111·0
g_1(js16)	*Nom* *Max* *Min*	1·6 1·9 1·3				2 2·3 1·7	2·5 2·8 2·2	3 3·3 2·7	4 4·4 3·6	5 5·4 4·6	6 6·4 5·6	7 7·4 6·6	9 9·4 8·6
g_2	*Nom*	2				2·5	3	4	5	6	7	9	11
h(js16)	*Nom* *Max* *Min*	10 10·4 9·6				12 12·6 11·4	16 16·6 15·4	20 20·6 19·4	25 25·6 24·4	32 32·8 31·2	36 36·8 35·2	45 45·8 44·2	56 57·0 55·0
m	*Nom*	5				6	8	10	12	14	16	20	24
r_1	*Nom*	3				4	5	6	8	10	11	14	18
r_2	*Nom*	*				*	*	*	1	1	1·2	1·6	2·5
r_3	*Nom*	0·5				0·5	1	1	1·2	1·2	1·6	2	3
r_4	*Nom*	2				2·5	3	4	5	6	7	9	11

*Radiused.

Bolts, Nuts and Fasteners Accessories Sectional Committee, EDC 27 [Ref : Doc : EDC 27 (1818)]

Adopted 15 May 1972

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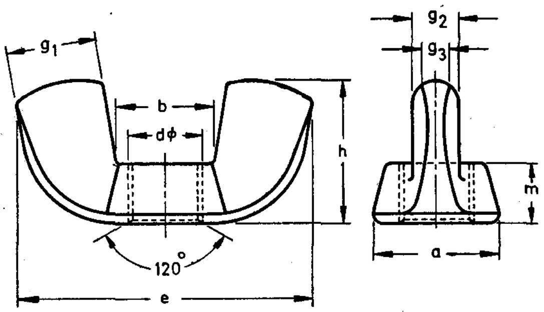
TABLE 2 DIMENSIONS FOR WING NUTS, TYPE B (COLD FORGED)

(*Clauses* 2 *and* 3.2)

All dimensions in millimetres.



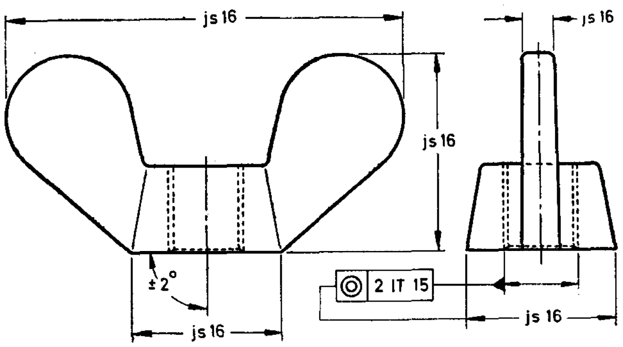
Size *d*		M3	M4 & M5	M6	M8	M10	M12	M16 & M20
a(js16)	*Nom*	8	11	12	14	17	22	29·5
	Max	8·45	11·55	12·55	14·55	17·55	22·65	30·15
	Min	7·55	10·45	11·45	13·45	16·45	21·35	28·85
b	*Nom*	5	6	8	9·5	12	16	22
e(js16)	*Nom*	16·5	21·5	27	31	36	47·5	68
	Max	17·00	22·20	27·60	31·8	36·8	48·3	69·00
	Min	16·00	20·80	26·40	30·2	35·2	46·7	67·00
g_1	*Nom*	5	7	8	9·5	11	15	20·5
g_2(js16)	*Nom*	2·5	3	4	5	5·5	7·5	9·5
	Max	2·8	3·3	4·40	5·40	5·90	8·00	10·00
	Min	2·2	2·7	3·60	4·60	5·10	7·00	9·00
g_3	*Nom*	1	2	2·5	3	3	4·5	5
h(js16)	*Nom*	9	11	13	16	18	23	35
	Max	9·40	11·60	13·60	16·60	18·60	23·60	35·80
	Min	8·60	10·40	12·40	15·40	17·40	22·40	34·20
m	*Nom*	3	4·5	5	6	7	9·5	13·5

3. Dimensions

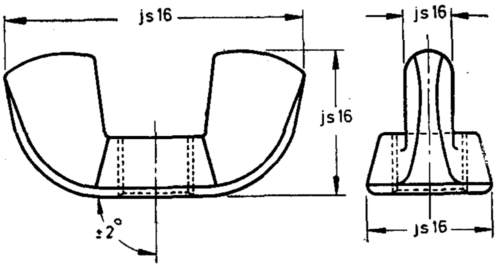
3.1 The dimensions of wing nuts manufactured from hot brass or other non-ferrous stampings or die castings, malleable iron castings, or hot steel stampings, etc, shall conform to Table 1.

3.2 The dimensions of wing nuts manufactured by cold forging steel or brass shall conform to Table 2.

4. Tolerances — The tolerances for the two types shall be as given below:



TYPE A



TYPE B

5. Mechanical Properties

5.1 The mechanical properties of the wing nuts manufactured from steel shall conform to the property class 4 as specified in IS : 1367-1967 ' Technical supply conditions for threaded fasteners (*first revision*) '.

5.2 When made of brass or non-ferrous material, the tensile strength shall be 300 MN/m^2 minimum.

6. Grade — Black (B) according to IS : 1367-1967.

7. Designation — The wing nut shall be designated by the type, size, and the number of this standard. If made of material other than steel, this shall be indicated at the end.

Examples:

a) A steel wing nut Type A of size M6 shall be designated as:

Wing Nut A M6 IS : 2636

b) A brass wing nut Type B of size M10 shall be designated as:

Wing Nut B M10 IS : 2636 — Brass

8. General Requirements

8.1 *Sampling* — The method of sampling and acceptance criteria to be in accordance with IS : 2614-1969 ' Methods for sampling of fasteners (*first revision*) '.

8.2 The wing nuts shall comply with the requirements of IS : 1367-1967 in respect of requirements not specified in the standard.

EXPLANATORY NOTE

This standard was originally prepared in 1964 and included only the hot stamped or cast type wing nuts. This standard now includes the cold forged type wing nuts also. For dimensions of hot stamped or cast wing nuts, assistance has been taken from DIN 315-1970 while the dimensions of cold forged type wing nuts are based on BS 856 : 1969. A separate clause (**4**) on tolerances has been added and these supersede the tolerances given in Fig. 37 of IS : 1367-1967.

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